Work Orde		85		*1	12585	*							Page	1
Revision ID:	D3594-044 Floor Doubler As	sembly, RH	A	Accept	*N9	റവ	040	100)*	Setup	Start Stop	*N!	S1*	
	1/30/14 S	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Custo	Item II mer:	D:							
Approvals:	Process Plan: QC:	•	Date: 14-02-03 Date:	Tooling: SPC (Y/N):	:	Γ	te: te:			Run	Start Stop	^IVI	R1* R2*	
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D3594	Rev B													
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120 +4 00 +	C	QC8- Inspect parts - sec	cond check	0.00	DAS 27 989			e ^{gr}	Ч					
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ļ		Crimp/Kiı	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified	L	Part Lost/M		Weld	
		Cuffs				Contamination		-	tions Incomplete/Unclear	L	Part Moved	L	Wrong Sto	ck Pulled
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1	<u> </u>	Wave/Tw	vist in Tul	be		Fit/Function		Out of	Sequence					

Work Order ID 112585 *112585* Page 2 January-30-14 11:50:39 AM Item ID: D3594-044 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Floor Doubler Assembly, RH *4* Start Oty: 4.00 **Start Date:** 1/30/14 **Cust Item ID:** Required Date: 1/30/14 Reg'd Oty: 4.00 *4* Customer: Reference: Run Start Process Plan: _____ Date: ____ Tooling: Date: **Approvals:** Stop SPC (Y/N): QC: _____ Date: Date: Reject Reject Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Insp. Number Stamp **Work Center ID** Code **Qty Qty Description Run Hours** 130 0.00 Small Fab *130* 0.00 Small Fab Memo C'SINK AS PER DWG D3594 Small Fab 0.00 140 QC5- Inspect part completeness to step on W/O *140* QC Memo Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150
HandFinish

Hand Finishing

Finish Memo

0.00

0.00

4 2/14-9

DQA:			Date:										TRAGE
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Work Ord January-30-14				*112	585*						Page 3	
Item ID: Revision ID: Item Name:	D3594-044 Floor Double	r Assembly, RH		Accept	*N90)NN4(ົ 1)* s	etup Start	171	S1* S2*	
Start Date: Required Date: Reference:	1/30/14 : 1/30/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Ite							
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Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool I	D Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	- 10
1 AO QC Quality Control		QC7-Inspect Chemical (Conversion Coat	0.00				<u> 4x</u>			14/04/10	DAS 36 9-89
170 *170* Small Fab Small Fab		Small Fab Memo Install Nut I	Plates As per Dwg D3594	0.00				<u>4x</u>			14/04/109	DAS 36 -89
180 *1 2 0*		QC5- Inspect part comp	leteness to step on W/O	0.00 0.00 0.00	7			4				

Quality Control

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Work	0	rd	er	ID	112	585
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112585 Page 4 Accept Item ID: D3594-044 *N900040100* Setup Start **Revision ID:** Floor Doubler Assembly, RH **Item Name:** *4* Start Oty: 4.00 **Cust Item ID: Start Date:** 1/30/14 Required Date: 1/30/14 **Req'd Qty:** 4.00 *4* **Customer:** Reference: Run Start Process Plan: **Tooling:** Date: Date: **Approvals:** Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Operation Qty Number Stamp **Work Center ID Description Run Hours** Code **Qty** Identify as per dwg & Stock Location: 57234 0.00 190 DAS *190* APR 1 0 2014 0.00 Packaging Memo Packaging 200 QC21- Final Inspection - Work Order Release 0.00 <u> 14-4-14</u> <u> 14.04-11</u> *200* 0.00 Memo Quality Control

DQA:			Date:										TRACT
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		Bending				Bend] Folio/I	Program	. [Outside Din	nensions	Pressure/Forced
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		Cracks				Broken/Damage/Defect		Hardwa	are	T	Part Incorre	ci	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	\vdash	Inspect	tion Incomplete/Unqu	ualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Und	clear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned \	Wrong	<u>-</u>
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss,	/Surge	Other
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		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence				

January-30-14 11:50:38 AM

Work Order ID:

112585

Parent Item:

D3594-044

Parent Item Name:

Floor Doubler Assembly, RH

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev : A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			170	sf	234.1600	0.51	2.1473684		1,	ــ /ند.ا.
6061-T6 .080 Sheet											<u></u>	2 1	<u> 1107/0</u> 1
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				MAT021	_	234.16							
•				(11	26309	218.9			00	2.1			
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MS20426AD4-4		Purchased	No			100	Each	3,436.0000	2	8	14/00	///	DAS 36 9-89
Rivet											4/4/	110	9-89
				Location		Loc Oty	L	oc Code			•		
				GA		339							
				129	090	339			8				
				ST334		3097							,
				125	5445	3097						/ /	/
MS21069-5		Purchased	No			170	Each	20.0000	1	4	ركبر	m/	DAS
Anchor nuts											17/4	<u>09 [0) </u>	36
				Location		Loc Oty	L	oc Code			/	/	3 6 9-89
				ST317		20							
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Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption		Date	Verification	┙	QC Inspector
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		Bending				Bend		 Folio/I	Program		-	Outside Dim	ensions		Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route	Г	Grain				Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	ci [Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Un	qualified		Part Lost/M	issing		Weld
		Cuffs				Contamination		Instruc	tions Incomplete/U	Inclear		Part Moved	L		Wrong Stock Pulled
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	L	Turning S	Sequence		L	Finish		Out of	Calibration						
		Wave/Tw	vist in Tub	oe		Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	112585
Description: Floor Doubler, RH	Part Number:	D3594-4
Inspection Dwg: D3594 Rev: B		Page 1 of 1

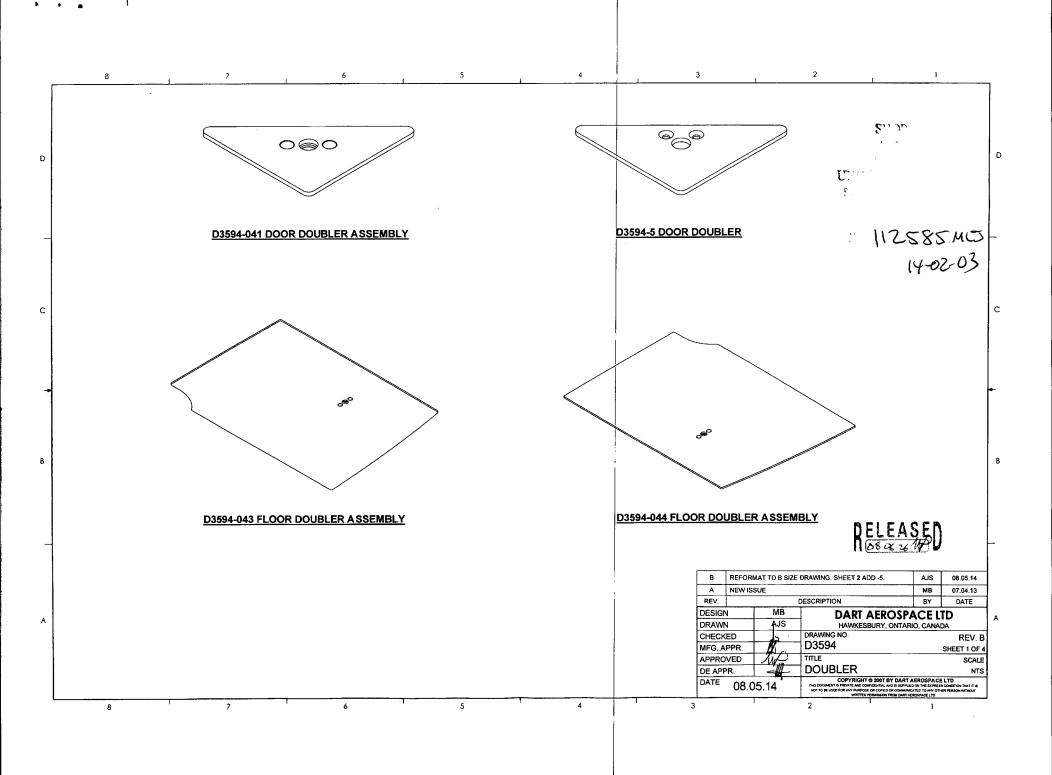
FIRST ARTICLE INSPECTION CHECKLIST

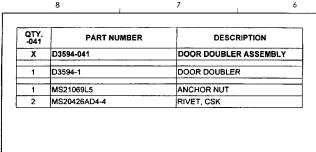
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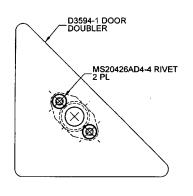
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7.85	+/-0.030	7.85	/		V51m-05	
7.313	+/-0.010	7.313	V		July 3	
2.688	+/-0.010	2688	V			7
Ø0.323	+0.006/-0.001	0,324	/			
Ø0.128	+0.005/-0.001	0.129				
0.359	+/-0.010	0.359	1			
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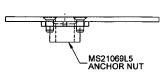
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Date: 14/04/07	Date: 14/4/7	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue P/O D3594-044	KJ/JLM //	
В	09.05.07	Dimensions updated per Dwg Rev B	KJ/EC C	/ X/ \
				10-4





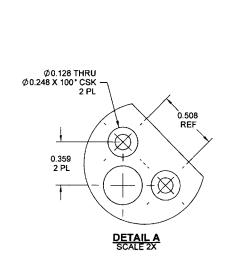


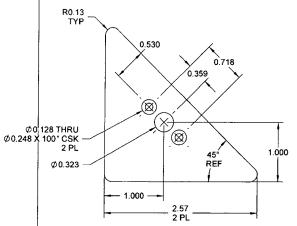


4 D3594-041 DOOR DOUBLER ASSEMBLY

D

NOTES:
1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

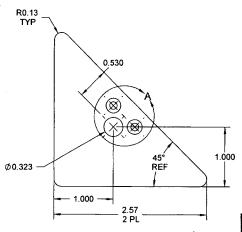




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D3594-1 DOOR DOUBLER

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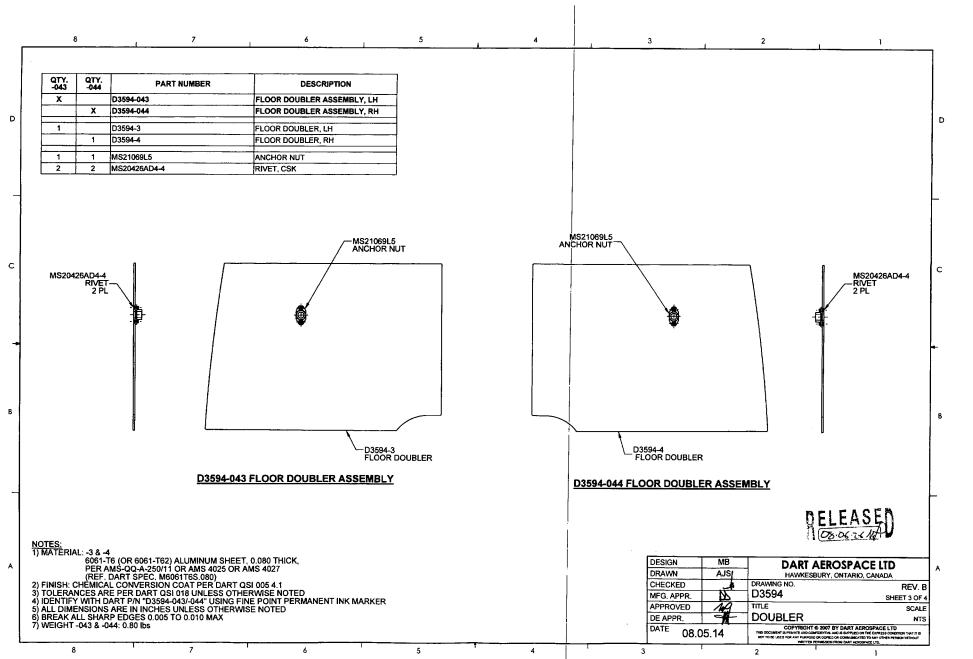


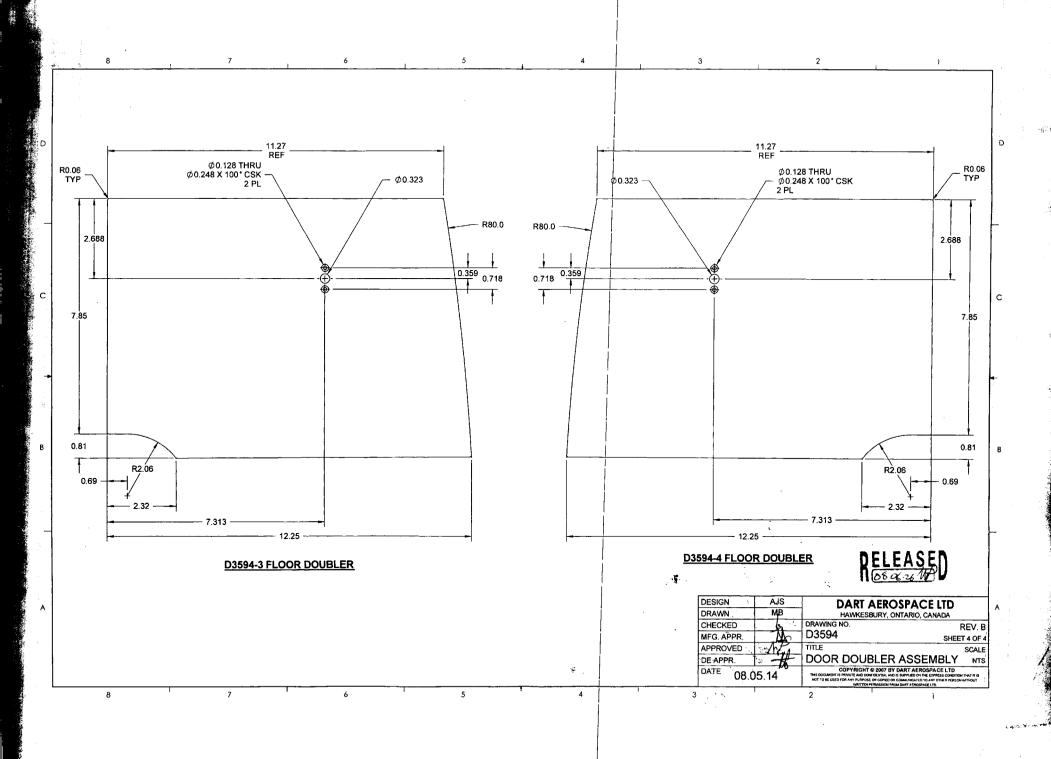
5 D3594-5 DOOR DOUBLER &

DESIGN	МВ	DART AEROSPACE LTD		
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	5.	DRAWING NO.	REV. B	
MFG. APPR.	20	D3594	SHEET 2 OF 4	
APPROVED	/Vista	TITLE	SCALE	
DE APPR.	-14-	DOUBLER	NTS	
DATE 08.0	5.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONCITION THAT IT IS		

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